

Work Order ID 139024

Friday, November 20, 2015 12:49:35 PM

139024

Page 1

Item ID: D3295-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacment Interior Window For -111
 Start Date: 11/13/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/13/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: NOV 20 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3295	E

100 FLOW WATER JET 0.00

100

Waterjet
FLOW CNC Waterjet

FLOW WATER JET

Memo 0.01
 ENSURE PLASTIC BLOCK ARE ON TABLE BEFORE CUTTING PARTS

1-Cut D3295-1 as per Dwg D3295

Dwg Rev: E

Prog Rev: E

2-Remove plastic, clean and wrap in saran wrap.

3-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC
Quality Control

Memo 0.00

Qty 1 -> Order to ship Feb 3

(4) _____ Dec 16/02/02

(4) _____ Dec 16/02/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Friday, November 20, 2015 12:49:36 PM

139024

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Replacment Interior Window For -111

Start Date: 11/13/2015 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 4.00 **1**

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							UAS 38 9-89
120						(Handwritten mark)			

120

QC

Quality Control

FEB 02 2016

130

130

Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3295. Put window in plastic wrap.

0.00

0.01

0.00

0.00

140

140

OC

Quality Control

DAS
38
9-89

FEB 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 11/13/2015 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/13/2015 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: SH436

0.00

150

Packaging

Memo

0.00

Packaging

DAS
6
9-89

FEB 03 2016

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

ML5

FEB 03 2016

MCS FEB. 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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139024

Parent Item: D3295-041

D3295-041

Parent Item Name: Replacment Interior Window For -111

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C05.06.20D3295-1 no longer made in-houseKJ/JLM
IPP Rev:D Added DT8822 07-03-20 JLM
IPP Rev:E Returned Manufacturing In House 07-06-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-9034-01		Purchased			No	100	sf	72.0000	1.24	5.221053			

MI FXS 125-9034-01

1/8" 9034 Lexan Sheet

OK 16/02/02

Location

Loc Qty

Loc Code

MAT019

72

125052

72

6.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER :																																																															

DART AEROSPACE LTD		Work Order: 139024
Description: Window		Part Number: D3295
Inspection Dwg: D3295	Rev: E	Page 1 of 1

*** FIRST ARTICLE INSPECTION CHECKLIST**

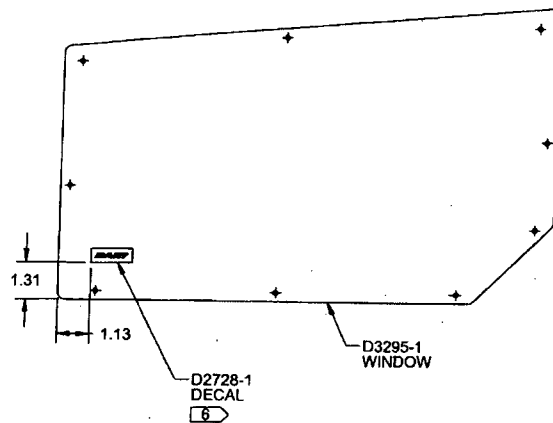
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	Ø .155	/		V-D-02	
17.13	+/-0.030	17.13	/		V-D-01	
10.43	+/-0.030	10.43	/		Taip	
14.35	+/-0.030	14.35	/			
8.98	+/-0.030	8.98	/			
0.625	+/-0.010	.627	/			
7.109	+/-0.010	7.108	/			
15.845	+/-0.010	15.849	/			
2.308	+/-0.010	2.309	/			
5.420	+/-0.010	5.423	/			
9.402	+/-0.010	9.406	/			
1.312	+/-0.010	1.313	/			
6.260	+/-0.010	6.263	/			
12.520	+/-0.010	12.520	/			
0.313	+/-0.010	.317	/			
3.750	+/-0.010	3.754	/			
8.150	+/-0.010	8.153	/			
9.006	+/-0.010	9.008	/			
0.125	+/-0.010	.120	/			

DAS
38

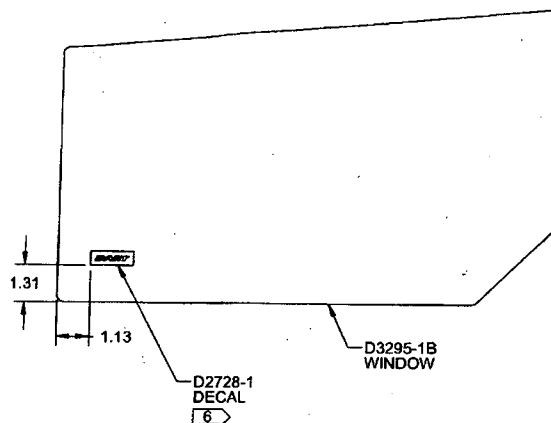
Measured by: <i>ac</i>	Audited by: 9-89	Preliminary Approval:
Date: 16/02/02	Date: FEB 02 2016	Date:

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	
B	13.02.27	Dwg Rev updated	KJ	<i>[Signature]</i>

ITEM	QTY -041	QTY -041B	P/N	DESCRIPTION
	X		D3295-041	FLOOR WINDOW
		X	D3295-041B	FLOOR WINDOW, BLANK
1	1		D3295-1	WINDOW
2		1	D3295-1B	WINDOW, BLANK
3	1	1	D2728-1	DECAL



D3295-041 FLOOR WINDOW



D3295-041B FLOOR WINDOW, BLANK

UNCOL... COPY
SUPER...
139.024 MWS
15-11-17

RELEASED
2012-11-21

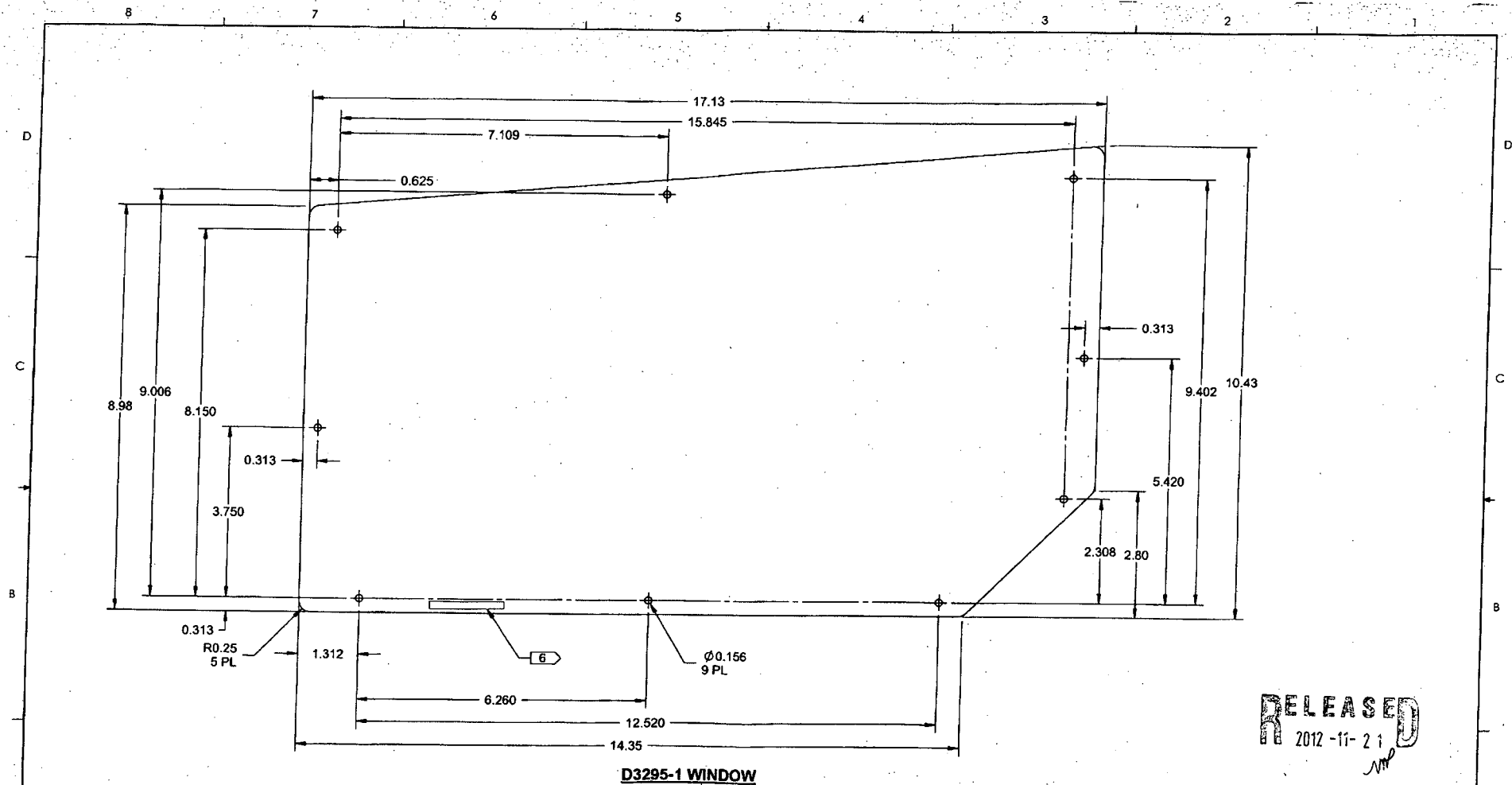
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) N/A
 - 6) ENSURE SURFACE IS FREE OF DIRT/GREASE PRIOR TO APPLICATION OF SELF-ADHESIVE DECAL
 - 7) WEIGHT: D3295-041/-041B = 0.87 lbs

E	ADD D3295-041B/-1B. REF. PAR12-223.	MB	12.11.15
D	REVISE MATERIAL TO LEXAN 9034 FROM POLYCAST ACRYLIC SHEET. ZONE A8 SH 2 ADD MISSING DIMENSION PER NCR 247. ZONE C3 SH 2 REFORMAT DRAWING	MP	07.11.07
C	CHANGE TEMPLATE # TO DT8822	SSH	07.02.21
B	UPDATE MATERIAL PER NCR 029	CP	06.04.13
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3295** REV. E
SHEET 1 OF 3
TITLE **FLOOR WINDOW** SCALE NTS

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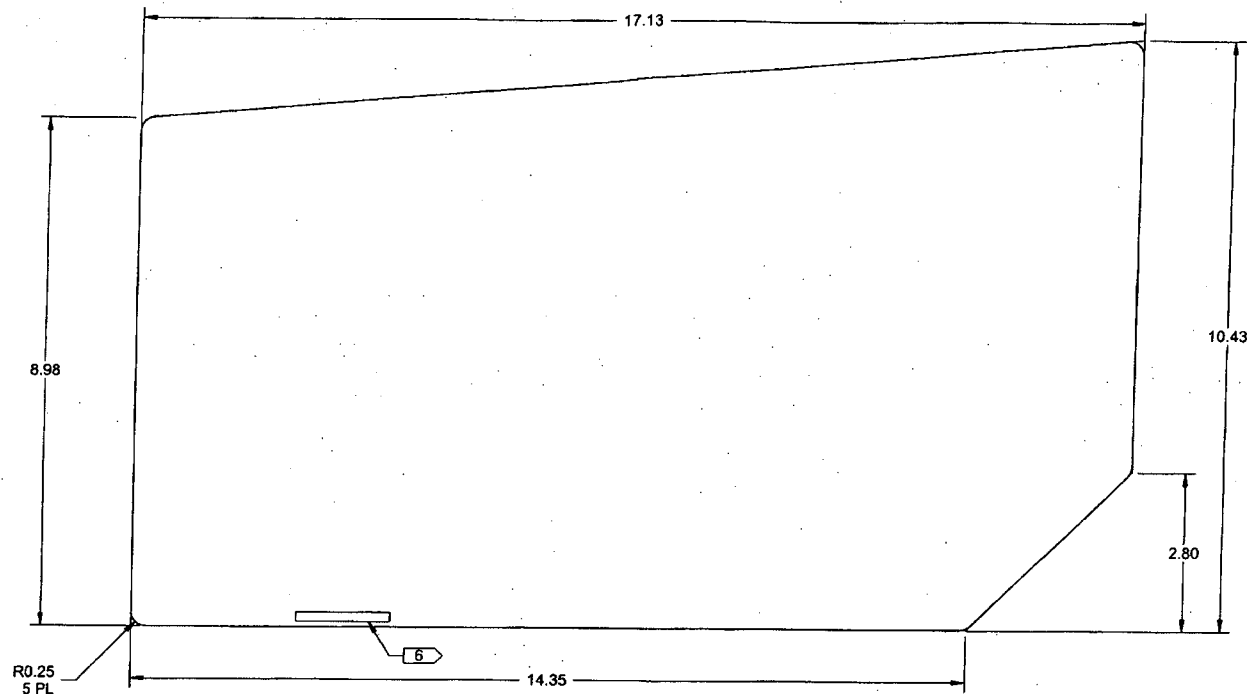


RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3295	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW	NTS
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D3295-1B WINDOW

RELEASED
2012-11-21
JMP

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK
REF DART SPEC. MLEXS.125-9034-01
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041B" AND B/N "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
USING LETTERS 0.125 TO MAX DEPTH OF 0.005. LOCATE APPROXIMATELY AS SHOWN.
- 7) WEIGHT: 0.87 lbs

DESIGN	gp	DART AEROSPACE LTD	
DRAWN	gp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	gp	DRAWING NO.	REV. E
MFG. APPR.	gp	D3295	SHEET 3 OF 3
APPROVED	gp	TITLE	SCALE
DE APPR.	gp	FLOOR WINDOW	NTS
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